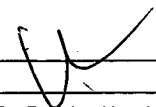
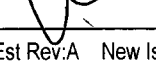


Date: Monday, 07/05/2007 7:50:02 AM  
 User: Linda Lacelle









## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 212S DETAIL PARTS
Job Number	: 32225		
Estimate Number	: 12839		
P.O. Number	: N/A	Part Number	: D2127251925
This Issue	: 07/05/2007 S.O. No. : N/A	Drawing Number	: D212-725-1 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 31958	Material	: N/A
Written By	: 	Due Date	: 14/05/2007 Qty: 5 Um: Each
Checked & Approved By	: 		
Comment	: Est Rev:A New Issue 07-04-19 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR1000WO49	304 RD Tube 1.0" x .049W
		
	Comment: Qty.: 1.9100 f(s)/Unit Total: 9.5500 f(s) 304 RD Tube 1.0" x .049W BATCH: M103841	
		FF 07-05-07 5
2.0	AN81816J	Nut
		
X	Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Nut Batch: M104203 (20)	
		FF 07-05-07 5
3.0	MS2081916J	Sleeve
		
X	Comment: Qty.: 2.0000 Each(s)/Unit Total: 10.0000 Each(s) Sleeve Batch: M104203 (x9) M103249 (1)	
		FF 07-05-07 5
4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1  1-Form as per Dwg D212-725-1 and Template DT8912.  2-Flare ends as per Dwg D212-725-1. ****ENSURE TO INSTALL SLEEVE & NUTS BEFORE FLARING****	
		FF 07-05-08 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/09

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 07/05/2007 7:50:02 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 212S DETAIL PARTS

Job Number: 32225

Part Number: D2127251925

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 07/05/09

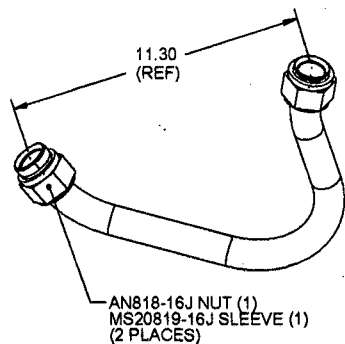
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

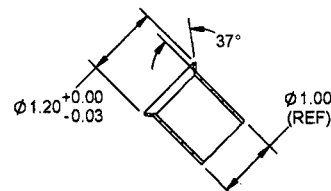
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

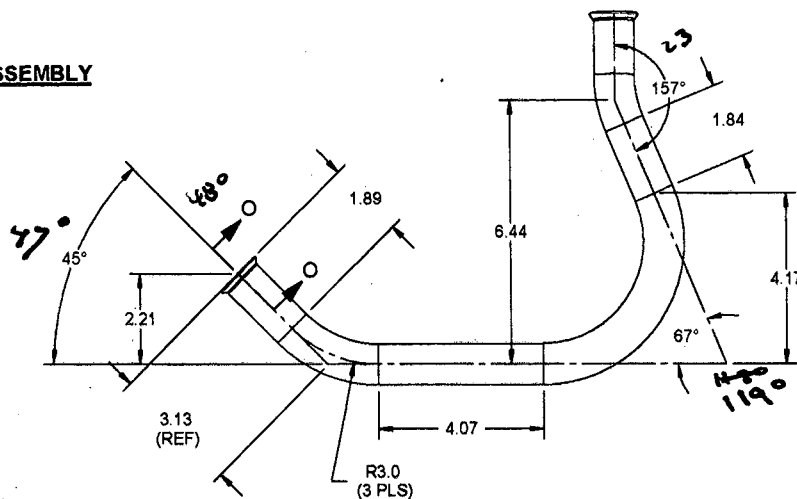
**NOTE:** Date & initial all entries



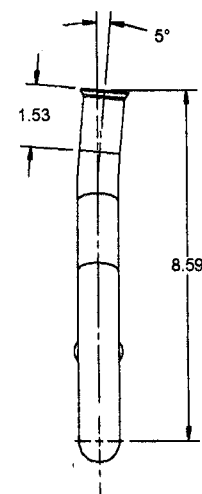
**D212-725-1-925 TUBE ASSEMBLY**



SECTION O-O  
SCALE 1:2  
(FINISH FLARE ONE END  
AFTER ASSEMBLY)



**D212-725-1-131 TUBING**  
MANUFACTURE PER TEMPLATE DT8912



**NOTES:**

- 1) MATERIAL: AISI 304/316 SS  $\phi 1.00$  X 0.049 WALL SEAMLESS ROUND TUBING (REF. DART SPEC. M304TR1.000W.049)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D212-725-1-925 USING FINE POINT PERMANENT INK MARKER

B	07.04.26	ADDED D212-725-1-131	
DESIGN DC	DRAWN BY RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED	DRAWING NO. <b>D212-725-1</b>	REV. B SHEET 42 OF 43
DATE <b>07.04.26</b>		TITLE <b>212S DETAIL PARTS</b>	SCALE 1:3
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